

Date: Tuesday, 29/04/2008 10:52:37 AM  
 User: Linda Lacelle

## Process Sheet

U6

Customer	CC-DAR01	Dart Aerospace Ltd.	Drawing Name	: TUBE	
Job Number	: 38883		Part Number	: D37701	
Estimate Number	: 10804		Drawing Number	: PROTOTYPE	
P.O. Number	:		Project Number	: 08.04.23	
This Issue	: 29/04/2008	S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	R & D SM/MED FAB	Due Date	: 16/05/2008
Previous Run	: 38876		Qty:	6	Um: Each
Written By	:		Comment	:	
Checked & Approved By	:		Comment	:	

## Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1  <b>MAKE PER DRWG D3770 REV A</b>		
2.0	M6061T6T1000W065	6061T6 TUBE
		
<b>Comment:</b> Qty.: 1.2000 f(s)/Unit Total : 7.2000 f(s) 6061T6 TUBE <del>6/10/2008</del> / <del>17/07/2008</del> <sup>PF 08.05.23</sup> <sup>6</sup> <sup>PF 08.05.12</sup>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
<b>Engineering Approval</b>  <b>Comment:</b> INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
<b>Comment:</b> HAND FINISHING RESOURCE #1  ACID ETCH AND ALODINE PER QSI 005		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION		

PF  
08.05.29

6

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User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: TUBE

Job Number: 38883

Part Number: D37701

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY

RF  
08.05.29

CHARGE TO JOB #00196

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

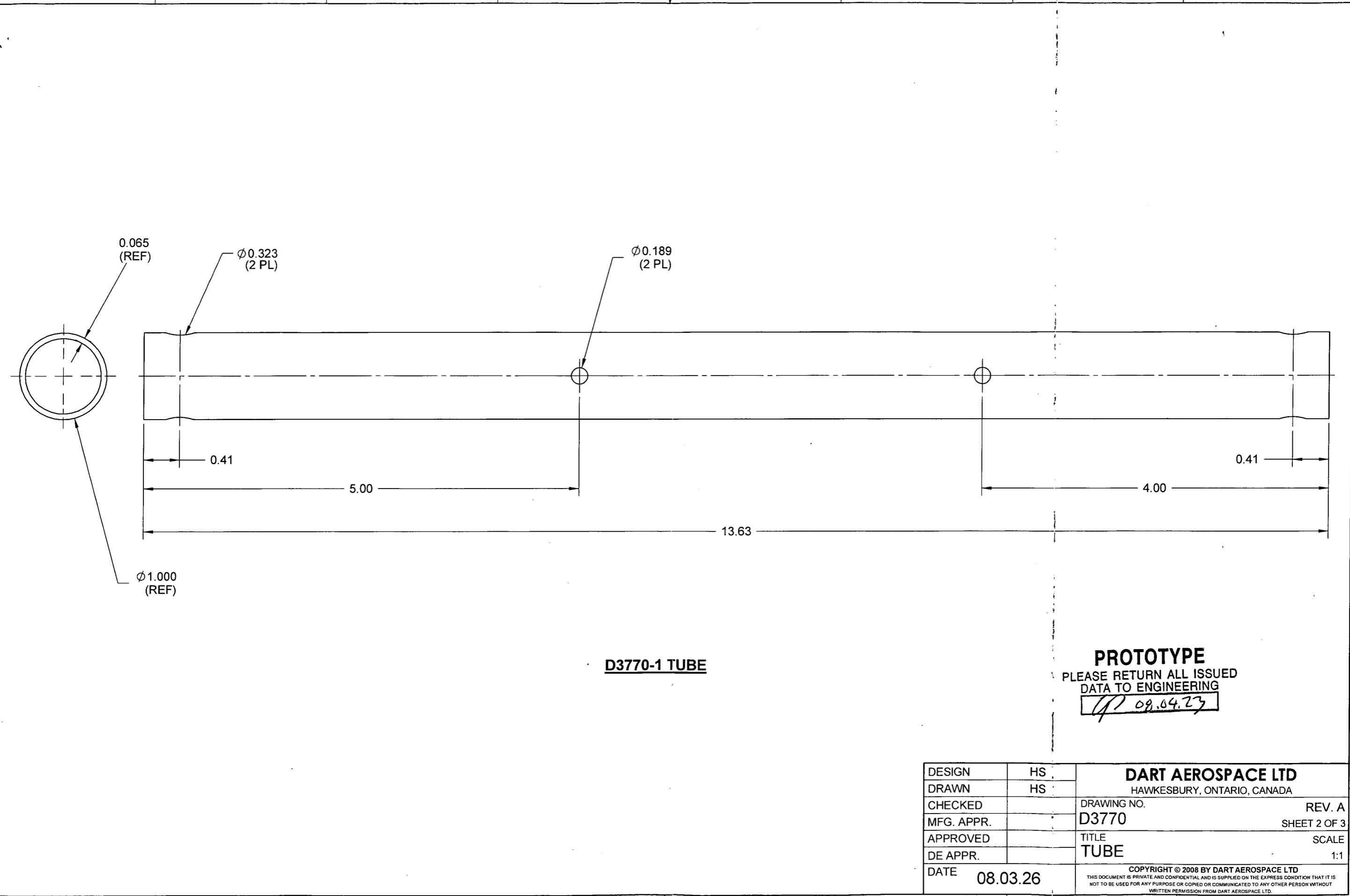
CERTIFICATE OF CONFORMITY  
REQUIRED

08.05.29 Prototype

Job Completion



08-06-01



8

7

6

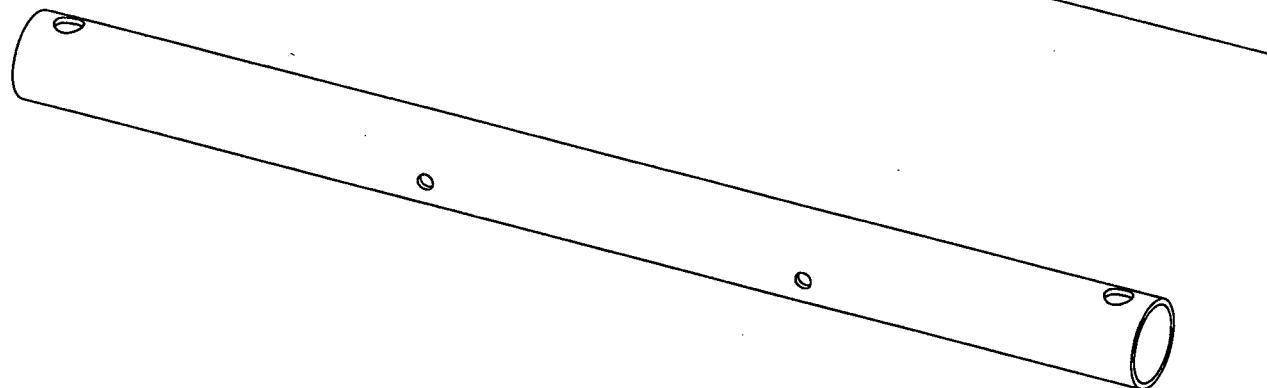
5

D

C

B

A



Cut

**D3770-1 TUBE**

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M60)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

8

7

6

5

4+



**D3770-3 TUBE**

**PROTOTYPE**

PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

*Q 08.04.23*

REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A	SHEET 1 OF 3
DRAWN	HS			
CHECKED		DRAWING NO.		
MFG. APPR.		D3770		
APPROVED		TITLE	SCALE	
DE APPR.		TUBE	NTS	
DATE	08.03.26	COPRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

M6061T6T1.000W.065)

# Receiving Report

Date: 8/6/08

Supplier: MARMON

Packing Slip: Yes  No   
 Invoice: Yes  No   
 Receipt: Cash  Cr

Batch No: M107950

Dart P/O: 6269

Release Note Attached: Yes  No  N/A   
 Waybill Attached: Yes  No   
 Shipment Complete: Yes  No  N/A   
 QC6 Inspection: Good  N/A   
 Work Order: 00000009  N/A   
 N/A   
 N/A

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) CD Level 12

Production/Admin:

Date 08/05/08

Received/Costing RCR 7822  
 Initial CD

Location  

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

## ORIGINAL INVOICE / FACTURE ORIGINALE

TERMS: NET 30 DAYS  
 PLUS 2% PER MONTH ON  
 OVERDUE ACCOUNTS.

TERMES: NET 30 JOURS  
 PLUS 2% PAR MOIS  
 SUR COMPTÉ PASSÉ Dû.

FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.  
 POUR LES CONDITIONS DE VENTE, VOUS TROUVEZ LES  
 RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

G.S.T. T.P.S.	/HST	18.02
PROVINCIAL TAX TAXE PROVINCIALE		.00

06/04/2008

378.38

PAYMENT OF THIS INVOICE IS DUE BY  
 LE RÉGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

EEB 18 2008 15:44 FR MARMON KEYSTONE

02/18/2008 From: MARMON/KEYSTONE  
M/K OR:  
C.P.O.:  
C.PART:

UNIT 3

To:

OR. REF:  
SLSPRS:

# **KAISER** **ALUMINUM** **FABRICATED PRODUCTS**

KAISER ALUMINUM  
FABRICATED PRODUCTS  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226

**CERTIFIED TEST REPORT**  
<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		PRODUCT DESCRIPTION:			
80-33503		AT/1..06S/734		Seamless Tube			
KAISER ORDER NUMBER: LINE ITEM:		SHIP DATE:		KAISER LOT NUMBER:		ALLOY:	TEMPER:
200438	005	11/27/2007		F00000606		5061	T6
WEIGHT SHIPPER	QUANTITY:	SA. NUMBER:		DIMM/DIA/THKNS:		WIDTH:	LENGTH:
331.000 LB	123.000 PCS	200274					12.000 FT
SHIP TO:				BOLD TO:			
MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA				MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA			

### Actual Physical Properties

REFERENCE	DASH#	SAMPLES	UTS (KSI)	TTS (KSI)	ELONG%	HARDNESS	CONTEX	SEND
F000000606	0001	1	46.5	42.6	17.0	N/A	N/A	N/A

#### Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cx	Zn	Ti	Pb	Bi	Br	Na	TDS
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R12452	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

**CERTIFICATION**

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Wilfredo A. delaCruz, Sr. Metallurgical Engineer

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

FEB 26 2023 13:10

AT 1.065 734

G. C. RENEWED

PAGE, 82

18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 1450541057

18/2008 FROM: MARMON/KEYSTONE

R OR:  
C.P.O.:  
C PART:

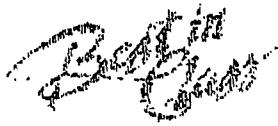
INIT.:

TO:

OR. REF:  
SLSPRS:

**KAISER**  
**ALUMINUM**  
**FABRICATED PRODUCTS**

KAISER ALUMINUM  
FABRICATED PRODUCTS  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226



**CERTIFIED TEST REPORT**  
<http://www.KaiserAluminum.com>

**Applicable Requirements:**

Description: OD: 1.000"; Wall: 0.065"; Round   
AMS-4082N ASTM-B210-04 WW-T-700/6P  
AMS-4082N, ASME-B210-04, WW-T-700/6P, WAS NOT OILED.  
WE TAKE EXCEPTION TO PARA. 5.2.1. PER AMS 4082N, WAS NOT OILED.  
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR  
CANCELED: MIL-T-7081, WW-T-700F/GEN, WW-T-700/2E, WW-T-700/3F,  
WW-T-700/4F, WW-T-700/5E, WW-T-700/6F, WW-T-700/7B.  
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204   
COMPLIES TO DIN EN 10204 JAN 2005

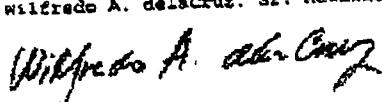
**Miscellaneous Notes**

MANUFACTURED IN USA MELTED IN USA

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Wilfredo A. de la Cruz, Sr. Metallurgical Engineer



Page 2 of 2

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

PAGE.03

FEB 06 2008 13:11

\*\* TOTAL PAGE.03 \*\*